

Work Order ID 64170

Friday, November 26, 2010 10:44:38 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 11/26/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

5- weld bushing as per dwg D3916

6- grind welds flush

[Signature] 10-12-20

SAD 10-12-15

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

[Signature] 10/12/21

[Signature] 10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 64170

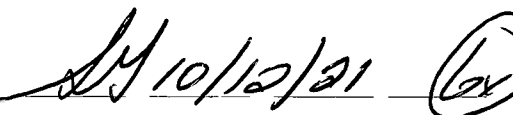
Friday, November 26, 2010 10:44:38 AM

Page 2

Item ID:	D3916-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly					
Start Date:	11/26/2010	Start Qty:	6.00	Cust Item ID:		
Required Date:	12/3/2010	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				6	0		
130  Packaging Packaging	Identify as per dwg & Stock Location: Basket cell Memo	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/12/21 

MF
10-12-21

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Picklist Print

Friday, November 26, 2010 10:44:43 AM

Page 1

Work Order ID: 64170

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 11/25/2010

Required Date: 12/2/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

23.0000

7



Bushing

Location

Loc Qty

Loc Code

ST084

3

56942

3

WA

20

54072

9

63875

11

M304TS0.750W.049

Purchased

No

100

f

131.5207

4.166

26.31158



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

8.15036794

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

MAT017

3.68448E-05

114298

3.6845E-05

WA

123.3703

114992

31.6993

115260

91.671

m116319

17.5416 + 3.000 = EMD Bar
8.770 Scrap

42
Pl 10.12.17
B63876 → (26)
B64421 → 16x
SAD 10-12-15

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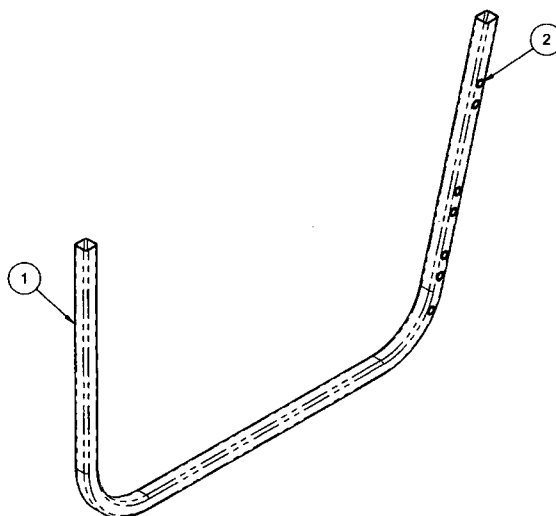
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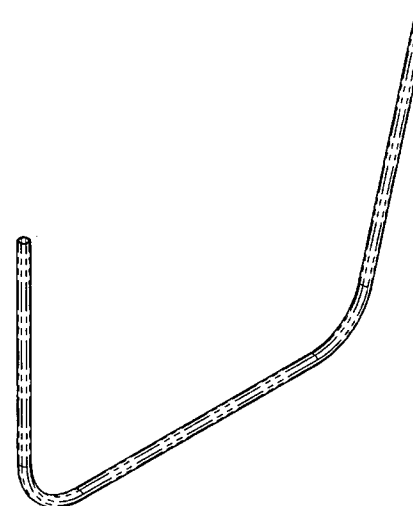
ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	J3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 64170

BS10-11-26



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

RELEASED
 2010-03-12
AMP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 DRAWING NO. **D3916**
 TITLE **RIB ASSY, 350 BASKET**
 REV. A
 SHEET 1 OF 4
 SCALE
 NTS

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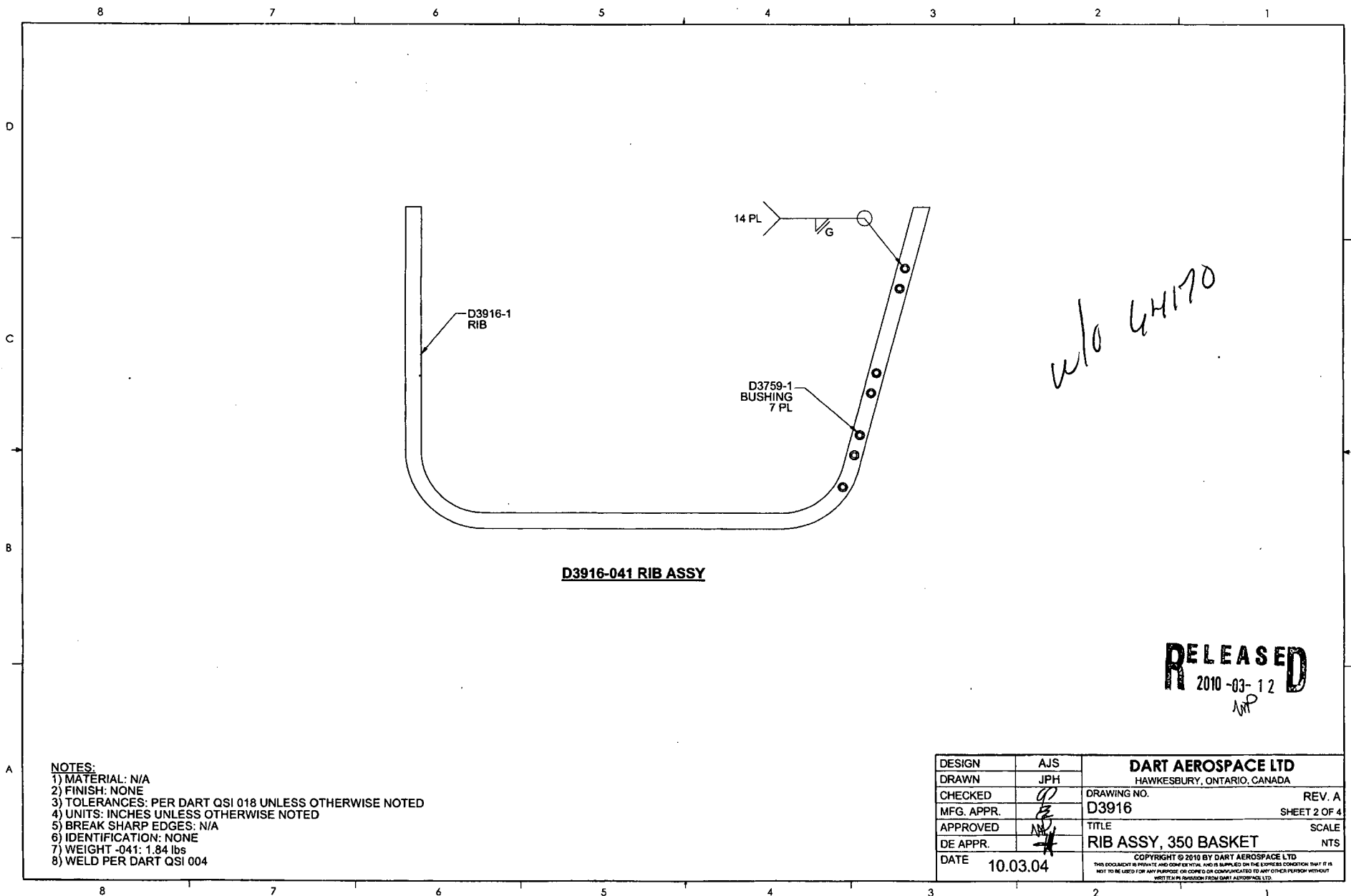
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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT -041: 1.84 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2010-03-12
[Signature]

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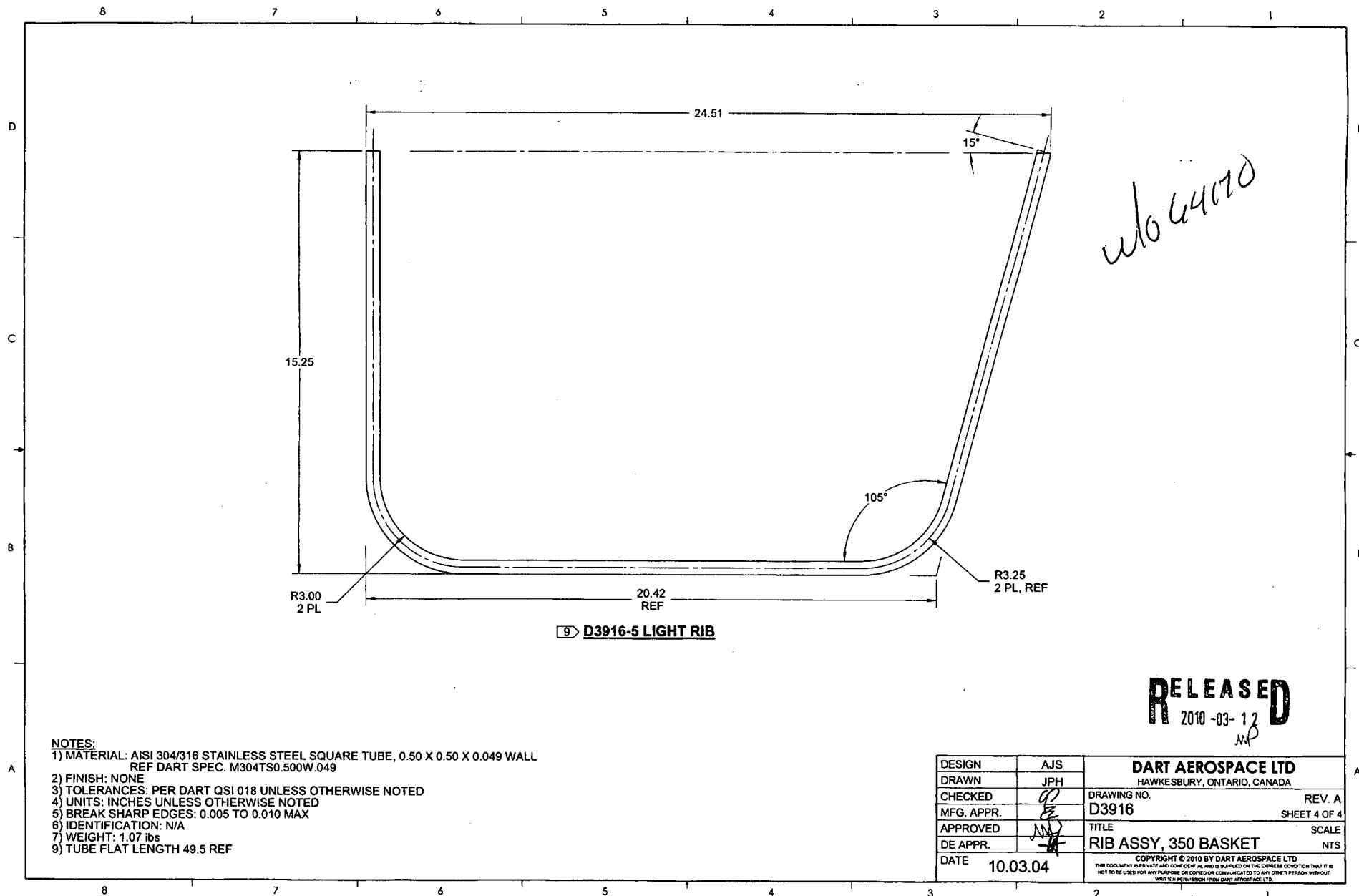
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